

Work Order ID 164226-2

Friday, July 14, 2017 11:53:56 AM

164226

Page 1

Item ID: D206-628-026BL

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Flight Step R/H For Mid Gear (Ael Blue)

Stop *NS2*

Start Date: 7/18/2017 Start Qty: 8.00

Required Date: 7/26/2017 Req'd Qty: 8.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: JUL 14 2017

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4308

A

IIN-D206-628

G

AUG 24 2017

100

Document Control

0.00

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D206-628-026
CHG 001

DAS
28
9-89

AUG 29 2017

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

①

8

AUG 24 2017

ml

DAS
27
9-89

QC. 4

Identify : sold

DAS
28
9-89

AUG 29 2017

DAS
28
9-89

AUG 29 2017

Work Order ID 164226***164226***

Friday, July 14, 2017 11:53:56 AM

Item ID: D206-628-026BL

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Revision ID:

Item Name: Flight Step R/H For Mid Gear (Ael Blue)

Start Date: 7/18/2017 Start Qty: 8.00

Required Date: 7/26/2017 Req'd Qty: 8.00

8

Cust Item ID:

Customer:

8

Reference:

Run Start ***NR1***Stop ***NR2***

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	QC4- 100% Inspect kits for completeness	0.00							
220									
QC	Memo	0.24							
Quality Control									
230	Identify as per dwg & Stock Location:	0.00							
230									
Packaging	Memo	0.00							
Packaging	Package per PPP D206-628-026 Location : FG127								
240	QC21- Final Inspection - Work Order Release	0.00							
240									
QC	Memo	0.80							
Quality Control									

DAS
28
9-89

AUG 30 2017

DAS
28
9-89

AUG 30 2017

DAS
21
9-89

AUG 30 2017

DAS
21
9-89

AUG 30 2017

Picklist Print

Friday, July 14, 2017 11:54:00 AM

Page 1

Work Order ID: 164226

164226

Parent Item: D206-628-026BL

D206-628-026BL

Parent Item Name: Flight Step R/H For Mid Gear (Aol Blue)

Start Date: 7/18/2017

Required Date: 7/26/2017

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP rev A 11.05.26 new issue EC verified by:DD
15.10.13 ADDED BL DD VERF:JLM

IPP REV:A

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4308-042BL *D4308-042BL* Step, RH Crew D2731-7RG *D2731-7RG* Mounting Lug		Manufactured	No			110	Each	0.0000	1	8			
									**	161596		AUG 2 9 2017	DAS 27 9-89
		Manufactured	No			110	Each	16.0000	2	16			
									**				DAS 27 9-89
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					AUG 2 4 2017	
					ST532	16	B163766	16					
					150806	2							
					159234	2							
					161253	12							
D3394-3RG *D3394-3RG* Lug		Manufactured	No			110	Each	24.0000	2	16			
									**				DAS 27 9-89
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					AUG 2 4 2017	
					ST532	24	B164022	14					
					140887	6							
					161254	18		2					
D4309-1 *D4309-1* Bushing		Manufactured	No			110	Each	58.0000	2	16			
									**				DAS 27 9-89
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					AUG 2 4 2017	
					ST091	58							
					159752	16							
					161533	42		16					

Picklist Print

Friday, July 14, 2017 11:54:00 AM

Page 2

Work Order ID: 164226

164226

Parent Item: D206-628-026BL

*D206-628-026BI *

Parent Item Name: Flight Step R/H For Mid Gear (Ael Blue)

Start Date: 7/18/2017

Required Date: 7/26/2017

Start Qty: 8.00

Required Qty: 8.00

AN4-11A
AN4-11A
BOLT

Purchased No

110 Each 88.0000 4 32

**

AUG 24 2017 DAS 27 9-89

Location

Loc Qty

Loc Code

FG	20	
120731	20	
ST344	68	4x M138170 28
M137495	68	

AN4-12A
AN4-12A
Bolt

Purchased No

110 Each 84.0000 4 32

**

AUG 24 2017 DAS 27 9-89

Location

Loc Qty

Loc Code

FG	10	4x M138209 18
120423	10	
ST344	74	
m137412	74	14

AN4-15A
AN4-15A
Bolt

Purchased No

110 Each 86.0000 2 16

**

AUG 24 2017 DAS 27 9-89

Location

Loc Qty

Loc Code

GA	10	
120449	10	
ST343	76	
m137820	76	M138040 16

MS21042-4
MS21042-4
Nut

MS21042L4

Purchased No

110 Each 2.0000 6 48

**

AUG 24 2017 DAS 27 9-89

Location

Loc Qty

Loc Code

ST304	2	M137988 48
9063	2	

Friday, July 14, 2017 11:54:00 AM

Shop Packet Print

Page 2

Picklist Print

Friday, July 14, 2017 11:54:00 AM

Page 3

Work Order ID: 164226

164226

Parent Item: D206-628-026BL

***D206-628-026BL ***

~~Parent Item Name: Flight Step B/U For Mid Gear (Aol Blue)~~

~~Start Date: 7/18/2017~~

~~Required Date: 7/26/2017~~

Start Qty: 8.00

Required Qty: 8.00

NAS1149D0463J

Purchased

No

110

Each

3,012.000

6

48

NAS1149D0463.I

Washer

**

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

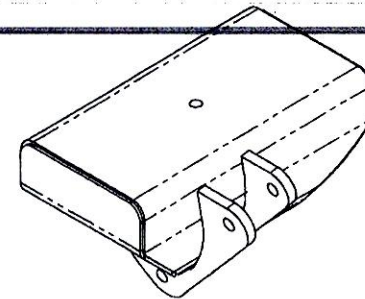
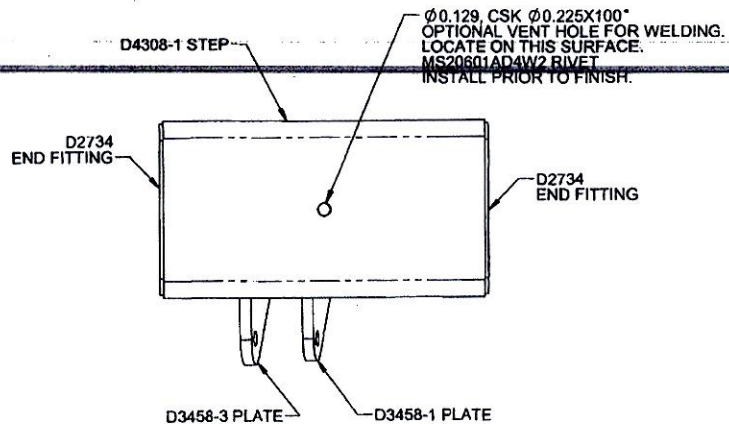
Loc Code

GA	560
M135056	40
M137699	520
ST260a	2000
M137699	1400
M137988	600
ST263	452
M137371	452

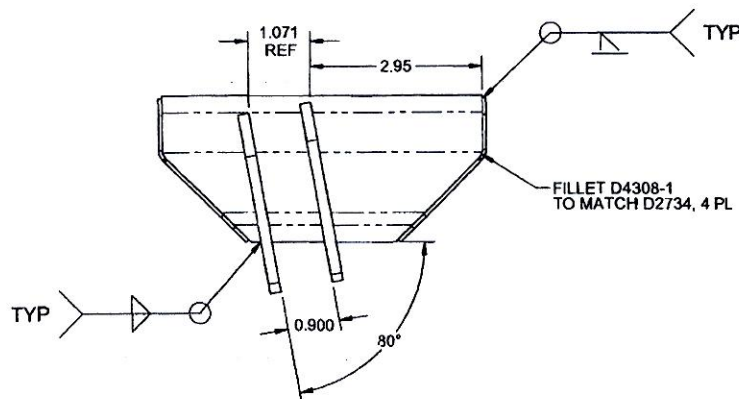
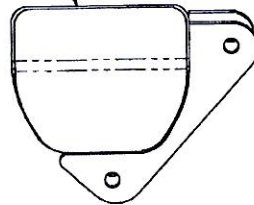
M138089 48

AUG 24 2017

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D4308-041	STEP, LH CREW
2	1	D4308-1	STEP
3	2	D2734	END PLATE
4	1	D3458-1	PLATE
5	1	D3458-3	PLATE
6	1	MS20601AD4W2	RIVET (OPTIONAL)



2 APPLY BLACK ANTI-SKID ON TOP SURFACE TO BOTTOM OF TOP RADIUS



D4308-041 STEP, LH CREW

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N & B/N PER DART QSI 044 6.6 (REMOVABLE TAG)
- 7) WEIGHT: 0.47 lb
- 8) WELDING: PER DART QSI 004

RELEASED
2011-05-26
JWP

REV.	NEW ISSUE	DESCRIPTION	CP	10.12.17
DESIGN			BY	DATE
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	10.12.17			

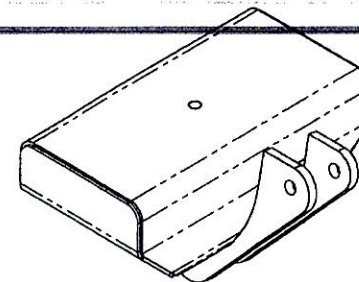
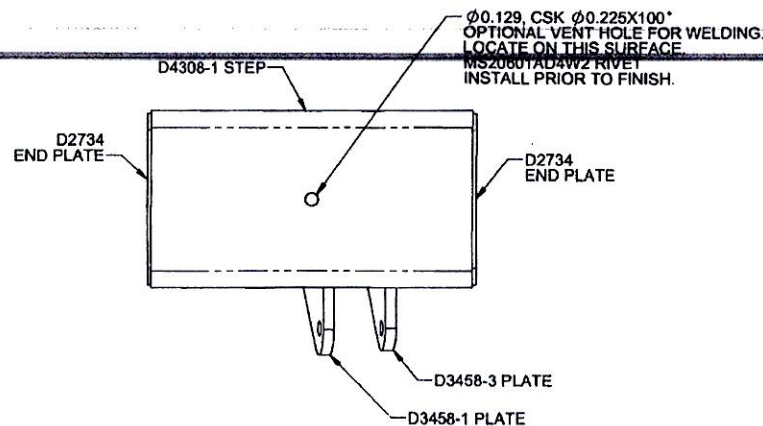
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4308** REV. A
SHEET 1 OF 3

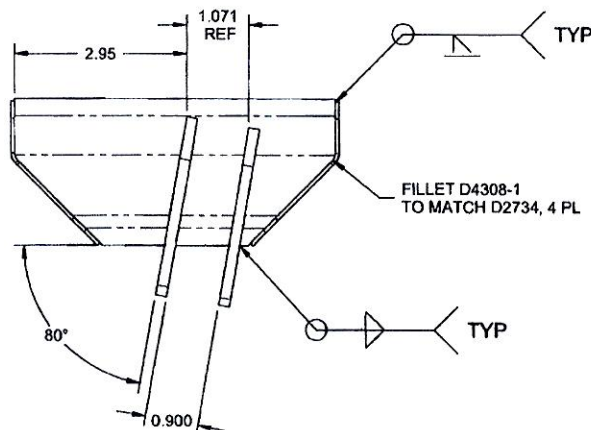
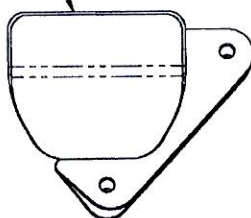
TITLE **STEP, CREW** SCALE NTS

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ITEM	QTY	P/N	DESCRIPTION
1	X	D4308-042	STEP, RH CREW
2	1	D4308-1	STEP
3	2	D2734	END PLATE
4	1	D3458-1	PLATE
5	1	D3458-3	PLATE
6	1	MS20601AD4W2	RIVET (OPTIONAL)



2) APPLY BLACK ANTI-SKID ON TOP SURFACE TO BOTTOM OF TOP RADIUS



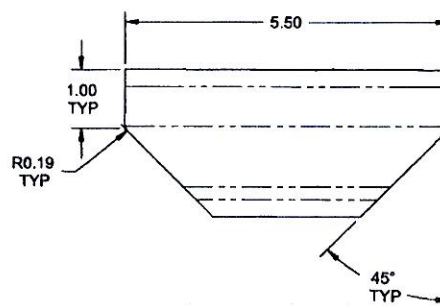
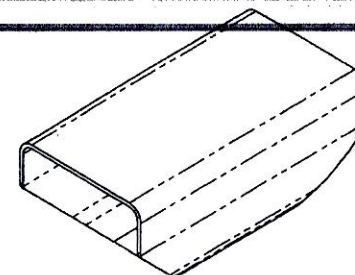
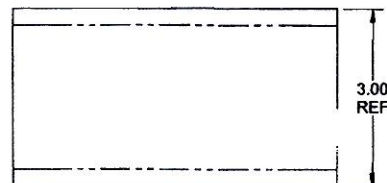
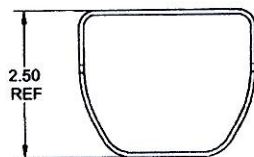
D4308-042 STEP, RH CREW

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N & B/N PER DART QSI 044 6.6 (REMOVABLE TAG)
- 7) WEIGHT: 0.47 lbs
- 8) WELDING: PER DART QSI 004

RELEASED
2011-05-24
AM

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4308	REV. A
MFG. APPR.			SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		STEP, CREW	NTS
DATE	10.12.17	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



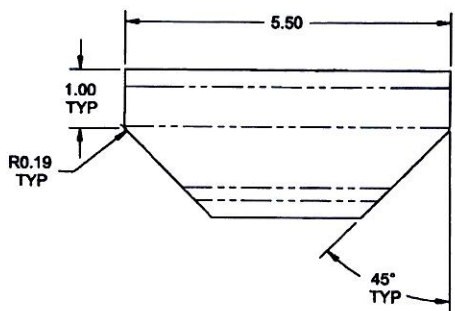
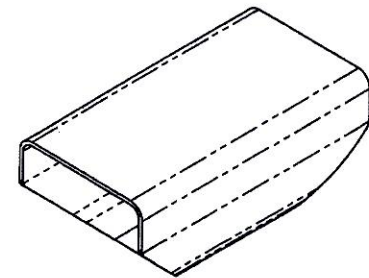
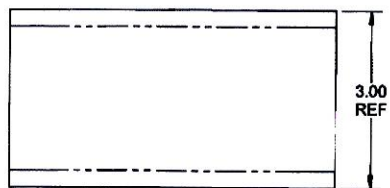
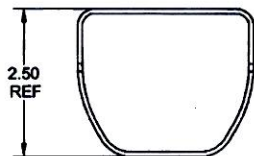
D4308-1 STEP

RELEASED
2011-05-20
JMO

NOTES:

- 1) MATERIAL: MAKE FROM D2622 EXTRUSION
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.33 lbs

DESIGN	g	DART AEROSPACE LTD	
DRAWN	g	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. A
MFG. APPR.		D4308	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		STEP, CREW	NTS
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D4308-1 STEP

RELEASED
2011-05-23
JWB

- NOTES:**
 1) MATERIAL: MAKE FROM D2622 EXTRUSION
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: 0.33 lbs

DESIGN	<i>JD</i>	DART AEROSPACE LTD	
DRAWN	<i>JD</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>ASS</i>	DRAWING NO.	REV. A
MFG. APPR.		D4308	SHEET 3 OF 3
APPROVED	<i>JD</i>	TITLE	SCALE
DE APPR.	<i>JD</i>	STEP, CREW	NTS
DATE	10.12.17	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

5.4 CREW STEP PARTS LIST

Qty -015	Qty -016	Qty -025	Qty -026	Qty -035	Qty -036	Part Number	Description
X						D206-628-015	CREW STEP, LH 206A/B
	X					D206-628-016	CREW STEP, RH 206A/B
		X				D206-628-025	CREW STEP, LH 206L/L-1/L-3/L-4
			X			D206-628-026	CREW STEP, RH 206L/L-1/L-3/L-4
				X		D206-628-035	CREW STEP, LH 407
					X	D206-628-036	CREW STEP, RH 407
				2	2	D2731-3RG	MOUNTING LUG
2	2	2	2			D2731-7RG	MOUNTING LUG
				2	2	D3394-1RG	MOUNTING LUG
2	2	2	2			D3394-3RG	MOUNTING LUG
		1		1		D4308-041	CREW STEP, LH
			1		1	D4308-042	CREW STEP, RH
2	2	2	2	2	2	D4309-1	BUSHING
1						D4357-041	CREW STEP, LH
	1					D4357-042	CREW STEP, RH
		4	4			AN4-11A	BOLT
4	4	4	4	4	4	AN4-12A	BOLT
2	2	2	2	2	2	AN4-15A	BOLT
6	6	6	6	6	6	MS21042-4	NUT
6	6	6	6	6	6	NAS1149D0463J	WASHER (AN960JD416)

5.5 MAINTENANCE STEP PARTS LIST

Qty -017	Qty -018	Qty -027	Qty -028	Qty -037	Qty -038	Part Number	Description
X						D206-628-017	MAINTENANCE STEP, LH 206A/B
	X					D206-628-018	MAINTENANCE STEP, RH 206A/B
		X				D206-628-027	MAINTENANCE STEP, LH 206L/L-1/L-3/L-4
			X			D206-628-028	MAINTENANCE STEP, RH 206L/L-1/L-3/L-4
				X		D206-628-037	MAINTENANCE STEP, LH 407
					X	D206-628-038	MAINTENANCE STEP, RH 407
2	2			2	2	D2731-3RG	MOUNTING LUG
		2	2			D2731-7RG	MOUNTING LUG
2	2			2	2	D3394-1RG	MOUNTING LUG
		2	2			D3394-3RG	MOUNTING LUG
2	2	2	2	2	2	D4309-1	BUSHING
		1		1		D4342-041	MAINTENANCE STEP, LH
			1		1	D4342-042	MAINTENANCE STEP, RH
1						D4358-041	MAINTENANCE STEP, LH
	1					D4358-042	MAINTENANCE STEP, RH
4	4	4	4	4	4	AN4-12A	BOLT
		4	4			AN4-13A	BOLT
2	2	2	2	2	2	AN4-15A	BOLT
6	6	6	6	6	6	MS21042-4	NUT
6	6	6	6	6	6	NAS1149D0463J	WASHER (AN960JD416)